

18

DART AEROSPACE LTD	Work Order:	19077
Description: Spacepod Floor	Part Number:	D3187-1 <i>03 05-01</i> D3187-2
Dwg: D3187 Rev. A	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>HA</i>	03.04.28	1
2	GA	Cut blank: (53.50" x 20.00") Material: 6061-T6 (QQ-A-250/11) 0.050" thick (M6061T6S.050) Batch: <i>111894</i> 111894	<i>HA</i>	03.04.28	1
3	GA	Cut & drill per template D3187-1T1 & Dwg D3187	<i>HA</i>	03.04.28	1
4	GA	Deburr	<i>HA</i>	03.04.28	1
<i>11a</i>	GA	Cut D2986 Neoprene Foam per template D2986T1 Batch: <i>D17866</i>	<i>HA</i>	03.04.30	1
<i>11b</i>	QC5	Inspect work up to Step 6	<i>HA</i>	03.04.30	1
8	FP	Acid etch and Alodine as per QSI 005 4.1	<i>HA</i>	03.04.28	1
9	FP	Powder Coat Black Sandtex (Ref. 4.3.5.7) per QSI 005 4.3	<i>HA</i>	03.04.28	1
10	QC3	Inspect Powder Coat	<i>HA</i>	03.04.30	1
11	GA	Attach Neoprene Foam using Contact Cement Note: D3187-1 OR D3187-2 side as per Dwg D3187	<i>HA</i>	03.04.30	1
12	QC5	Inspect work to Step 11	<i>HA</i>	03.05.01	1
13	GA	Go to KP <i>181.34 sub 03/05/02</i>	<i>HA</i>	03.05.01	1

INSPECT LEVEL 21 *HA* 03.05.01

Rev	Date	Change	Revised By	Approved
A	03.04.22	New Issue	KJ/RF <i>HA</i>	<i>HA</i>

RELEASED
03.04.28 *HA*

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

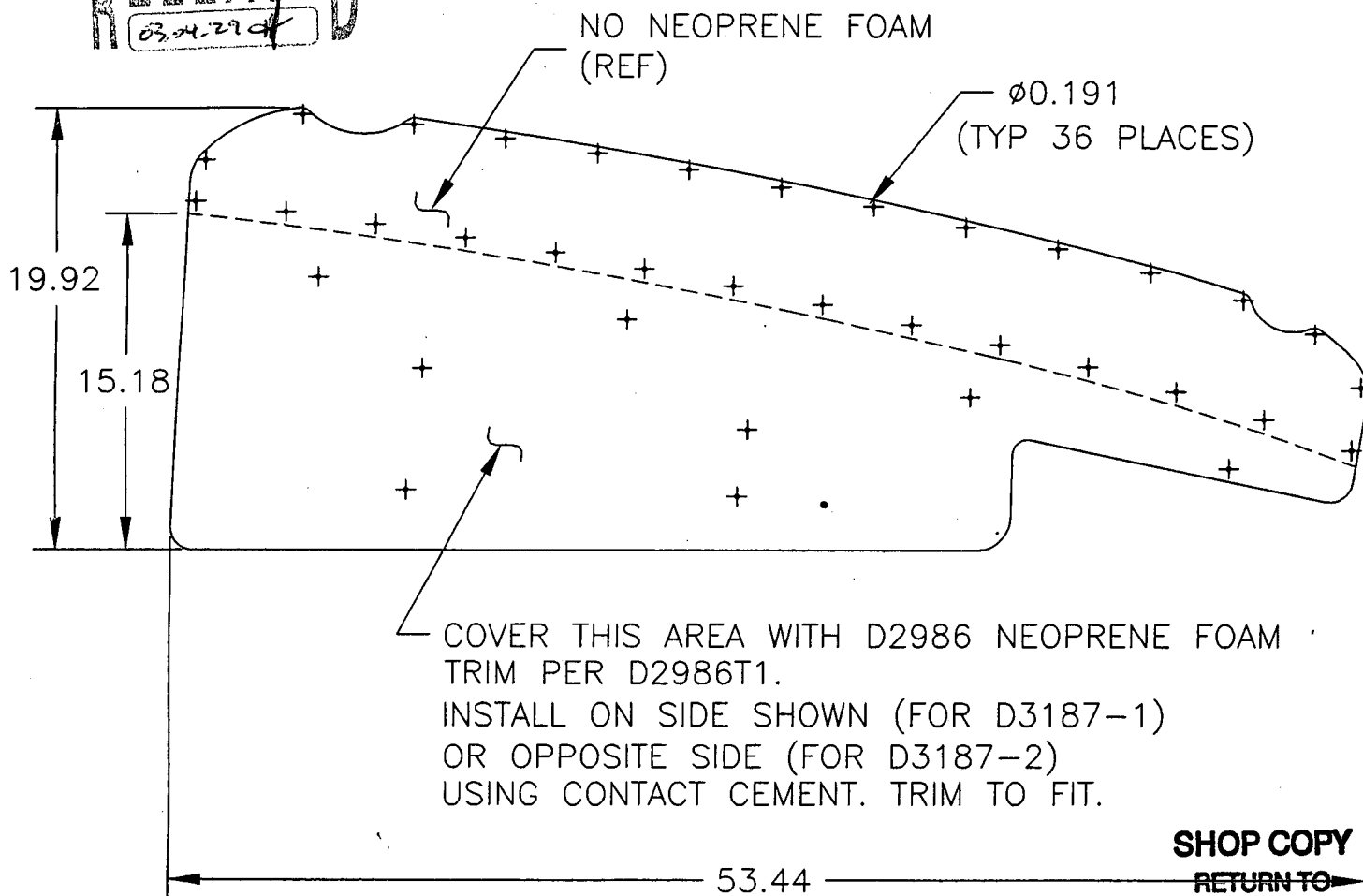
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3187	REV. A SHEET 1 OF 1
DATE 03.03.31		TITLE SPACEPOD FLOOR	SCALE NTS
A	03.03.31	NEW ISSUE	

RELEASED
03.04.29



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WORK ORDER

NO. 19077

D3187-1/-2 SPACEPOD FLOOR

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
Hawkesbury

Job Costing Report

Apr 28, 2003
01:19 pm

Work Order No : 0019077S
Project Name : D3187-2
Project For : WK18
Work Order Type : Main
Main WO Number :
House Part Number : D3187-2
Description : Spacepod Floor
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-28-03
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

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Dart Aerospace Ltd.
Hawkesbury

Job Costing Report

Apr 28, 2003
01:19 pm

Work Order No : 0019077
Project Name : D3187-1
Project For : WK18
Work Order Type : Main
Main WO Number :
House Part Number : D3187-1
Description : Spacepod Floor
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-28-03
Est Finish Date : 04-29-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

Labour Hrs/Amount Done	Estimated	Actual
Profits/(Loss)	0.00	0.00
	0.00	0.00